

Date: Thursday, 9/14/2006 7:29:21 AM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : OUTLET ADAPTER PLATE  
 Job Number : 28563  
 Estimate Number : 12161  
 P.O. Number : *NIA* Part Number : D34751  
 This Issue : 9/14/2006 S.O. No. : *NIA* Drawing Number : D3475 REV B  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : *NIA* Type : SMALL / MED FAB Drawing Revision : B  
 Previous Run : 26278 Material : *NIA*  
 Due Date : 10/6/2006 Qty: 4 Um: Each  
 Written By : *[Signature]*  
 Checked & Approved By : *[Signature]* 06 09 14  
 Comment : Est Rev:A New Issue 06-02-02 JLM  
 Est Rev:B As per Rev B 06-05-24 JLM

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304S26GA 304/316 0.018 SHEET



Comment: Qty.: 0.0857 sf(s)/Unit Total : 0.3427 sf(s)

304/316 0.018 SHEET

Batch: *M101000* *MA 06 09 18*

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1


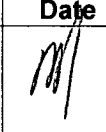
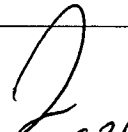
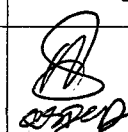
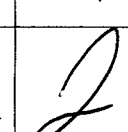
1-Deburr if necessary. *SAD 06:09:25* (4)

2-Form as per Dwg D3475 using Dt8847 A&B on press. *SB 06/09/27* (4)

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☒ DQA: ☒ Date: 06/07/24  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/07/24	1.	Parts were made with 18 gauge by mistake, instead of .019"		Distron ? Replace with proper material	 06/07/24	 06/07/26		 06/07/26

**NOTE:** Date & initial all entries

Date: Thursday, 9/14/2006 7:29:21 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: OUTLET ADAPTER PLATE

Job Number: 28563

Part Number: D34751

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

RB 0609.27

(4)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location GA

SB 06/09/27

(4)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

SB 0609.27

(4)

Job Completion



W 06.09.27

**Dart Aerospace Ltd**

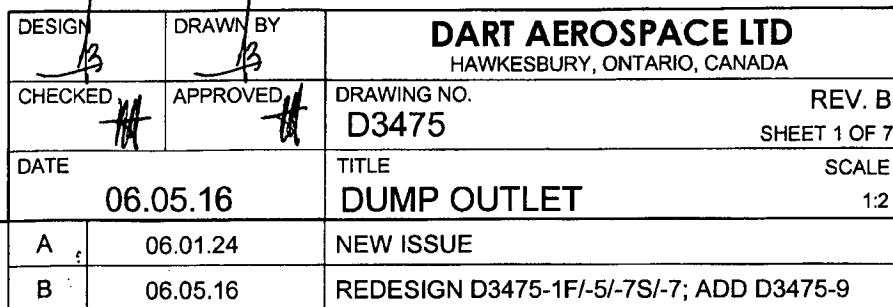
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

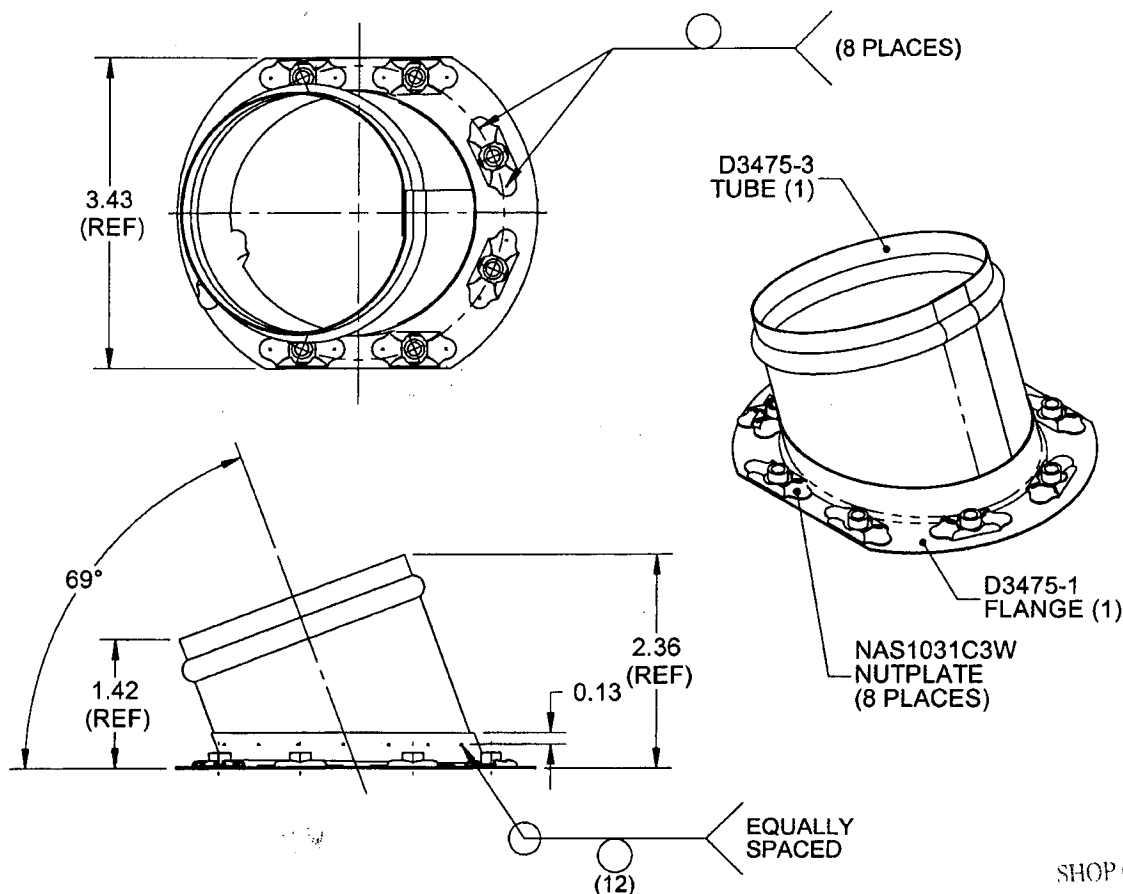
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



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06-05-16



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**NOTES:**

- 1) SPOT WELD PER DART QSI 004
- 2) IDENTIFY WITH DART P/N D3475-041 USING FINE POINT PERMANENT INK MARKER
- 3) FINISH: NONE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

QTY -041	P/N	DESCRIPTION
X	D3475-041	DUMP OUTLET
1	D3475-1	FLANGE
1	D3475-3	TUBE
8	NAS1031C3W	NUTPLATE

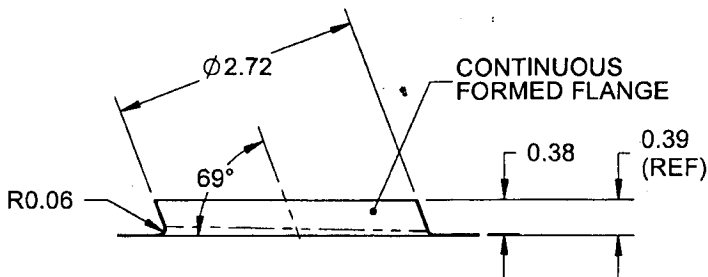
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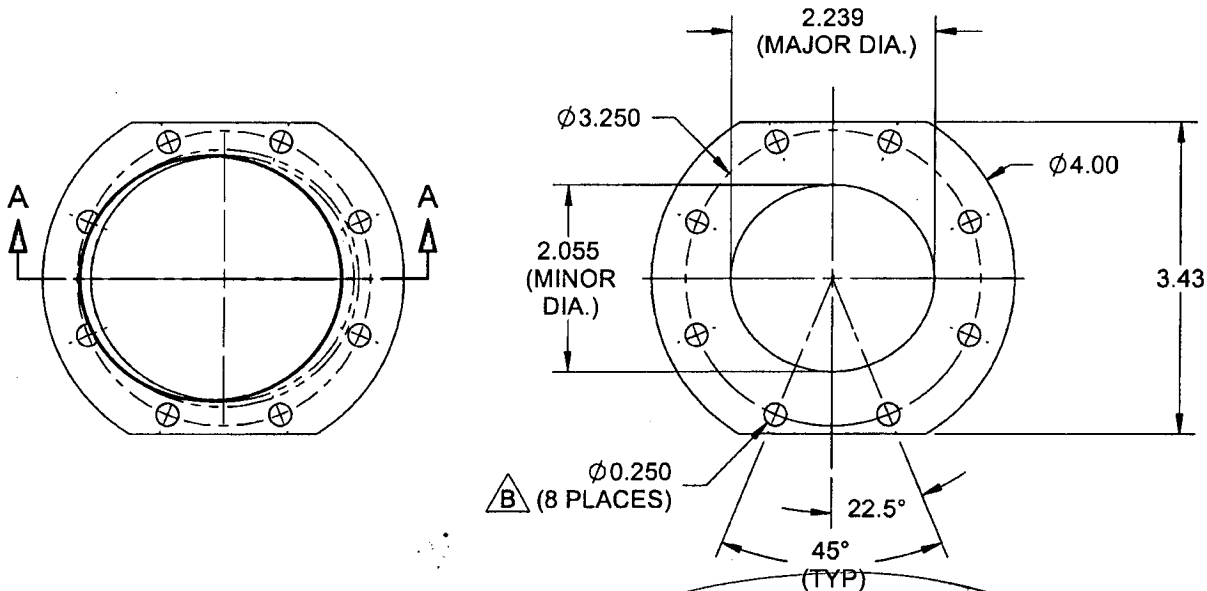


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DATE 06.05.16	TITLE DUMP OUTLET		SCALE 1:2

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**SECTION A-A**



**D3475-1 OUTLET  
ADAPTER PLATE**

**D3475-1F FLAT PATTERN**

**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH  
26 GAUGE SS (0.018 THICK)  
(REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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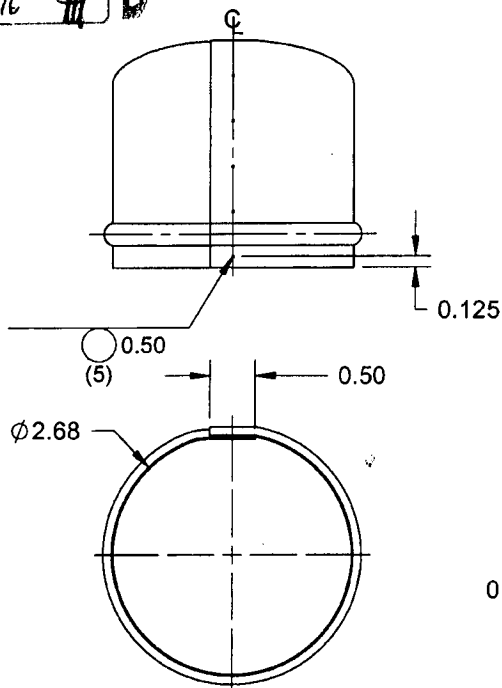
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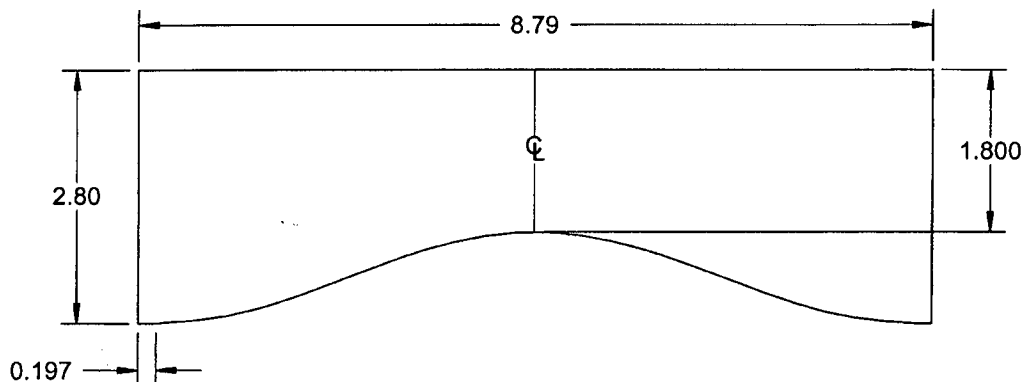
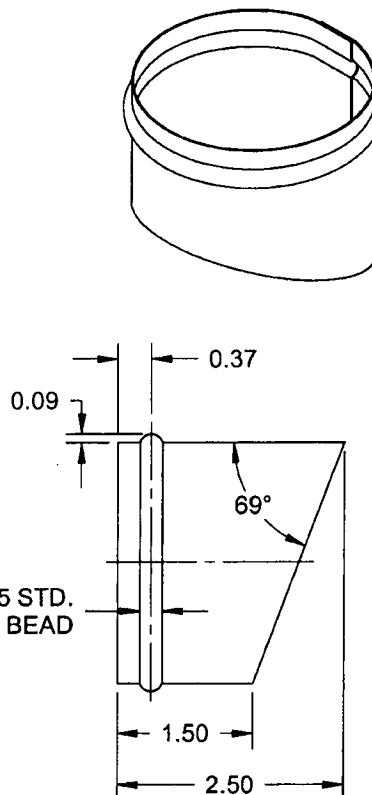


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DATE <b>06.05.16</b>	TITLE <b>DUMP OUTLET</b>		SCALE 1:2

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06.05.16 H



**D3475-3 TUBE**



**D3475-3F TUBE FLAT PATTERN**

**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH  
26 GAUGE SS (0.018 THICK)  
(REF. DART SPEC. M304S26GA)
- 2) FLAT PATTERN IS SYMMETRICAL ABOUT CENTERLINE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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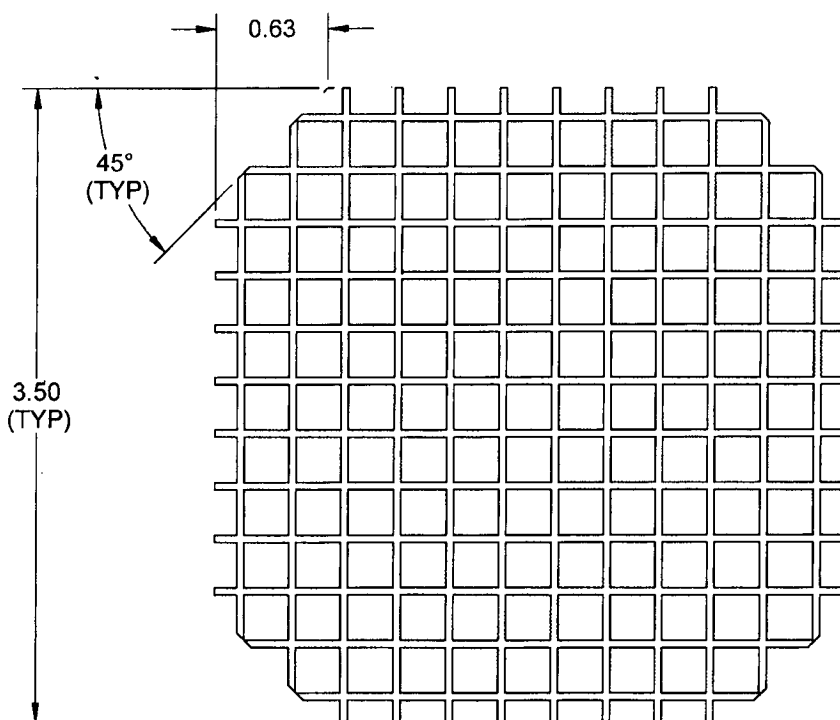
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DATE <b>06.05.16</b>		TITLE <b>DUMP OUTLET</b>	SCALE 1:1

**RELEASED**  
*06.05.16*



### **D3475-5 SCREEN**

#### **NOTES:**

- 1) MATERIAL: #4 MESH SCREEN, 0.203" OPENING,  $\phi$ 0.047" WIRE  
(REF. DART SPEC. M304MS4.203-.047)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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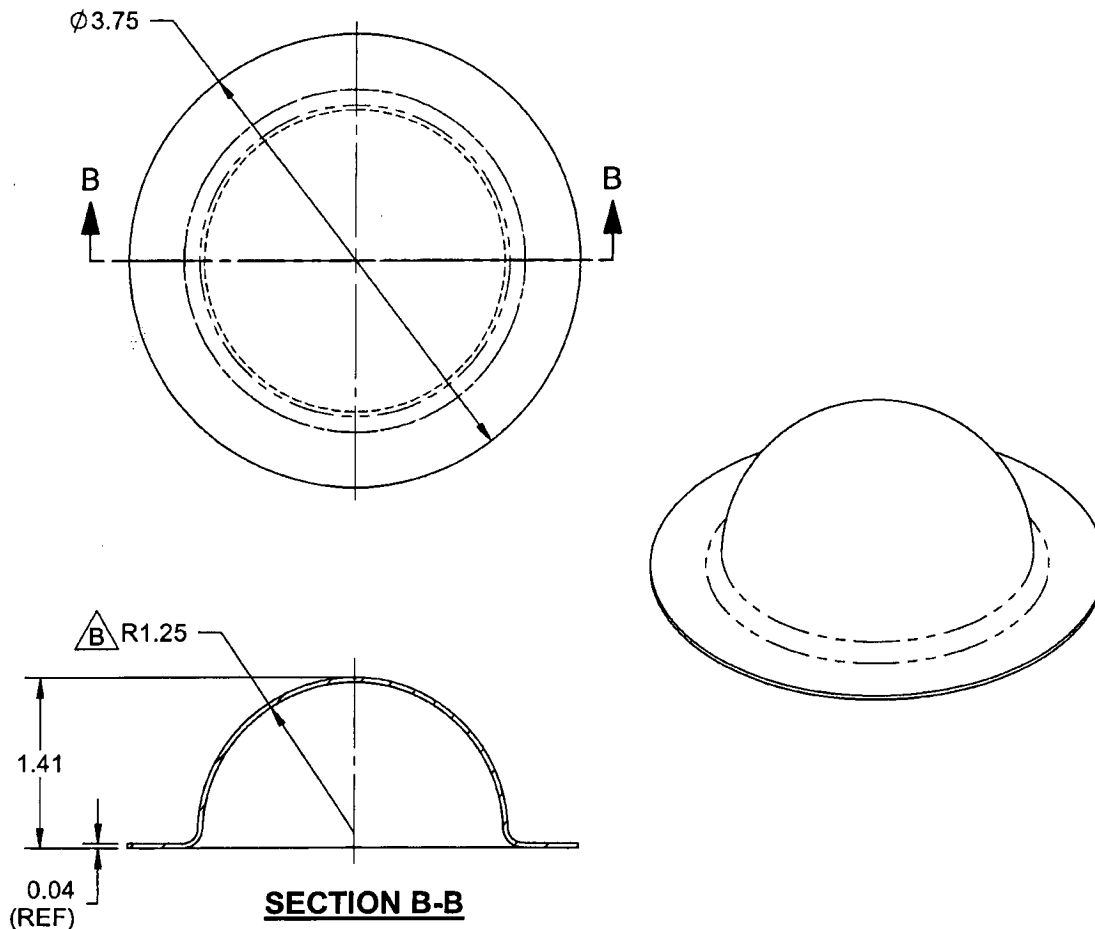
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DATE 06.05.16		TITLE DUMP OUTLET	SCALE 1:1.5

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06.05.16 *[Signature]*



**D3475-7S SCOOP OUTLET, SPINNING DETAIL**

**NOTES:**

- 1) MATERIAL: 2024-0 ALUMINUM SHEET, 0.040" THICK PER AMS-QQ-A-250/4 OR AMS 4037 (REF. DART SPEC. M2024T0S.040)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

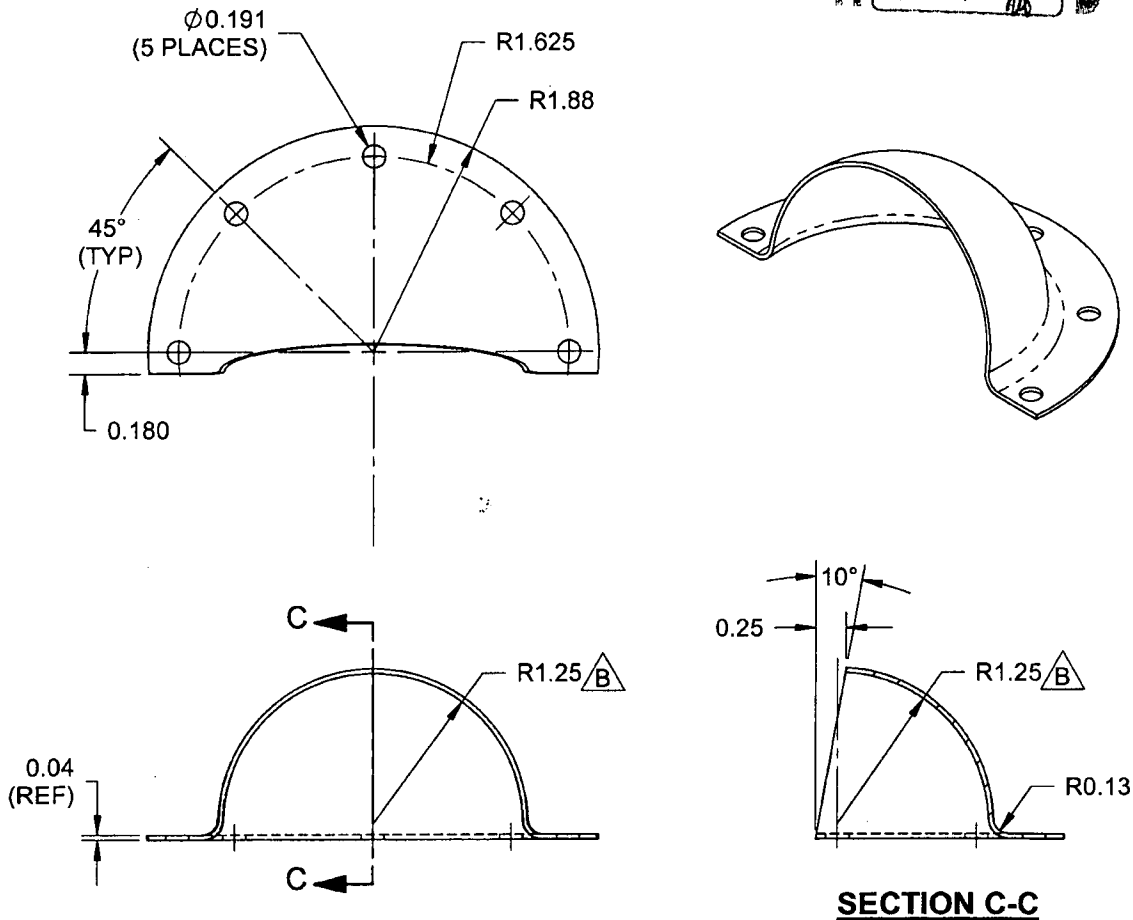
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DATE 06.05.16		TITLE DUMP OUTLET	SCALE 1:1.5

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06.05.16 *H***D3475-7 SCOOP OUTLET****NOTES:**

- 1) MATERIAL: MAKE FROM D3475-7S
- 2) IDENTIFY WITH DART P/N D3475-7 USING FINE POINT PERMANENT INK MARKER
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES  $0.005$  TO  $0.010$

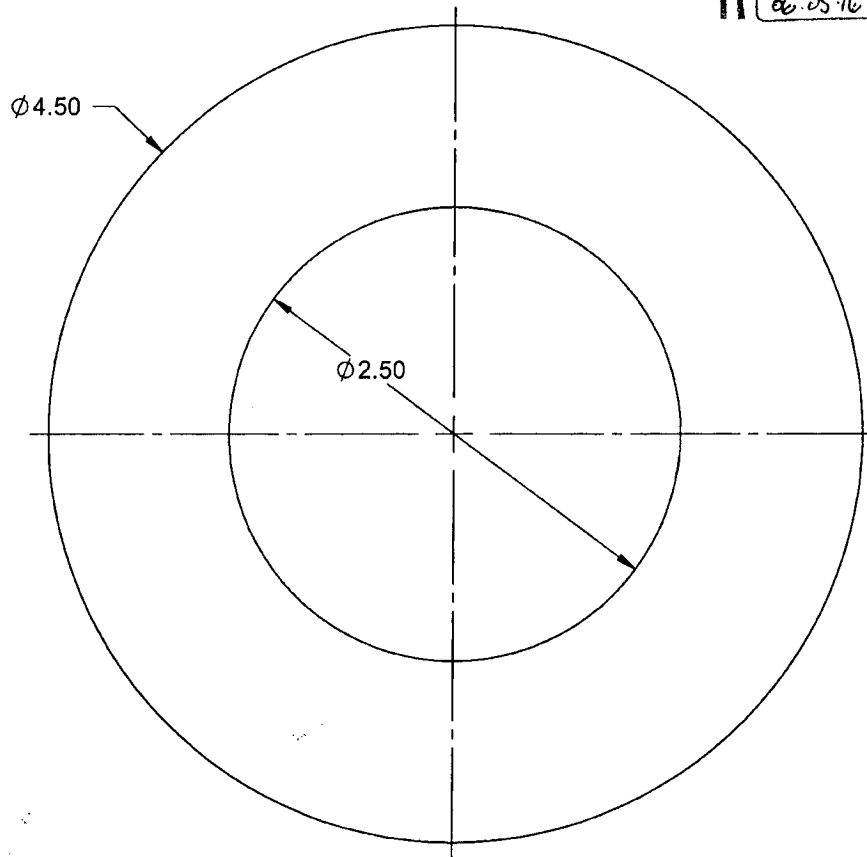
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DATE <b>06.05.16</b>		TITLE <b>DUMP OUTLET</b>	SCALE 1:1

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*06.05.16***D3475-9 OUTLET GASKET****NOTES:**

- 1) MATERIAL: RED (OR GRAY) 60 DUROMETER HI-TEMPERATURE SILICONE SHEET, 0.063 THICK (REF. DART SPEC. M-SIL60-S.063)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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